

Date: Monday, 3/26/2007 3:23:00 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 31483	
Estimate Number : 10707	
P.O. Number : <i>N/A</i>	Part Number : D2012105
This Issue : 3/26/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2012 REV D1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i>	Drawing Revision : D1
Previous Run : 30299	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 4/8/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>15</i> Um: Each
Comment : Est Rev: 02.04.03 Added Inspect level 3 NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 2.7567 f(s)/Unit Total : 13.7834 f(s)
 Material: 304/316 Seamless SS tubing, 1/2" O.D. x .035" wall(M304TR0.500W.035)
 Identify as D2012-101 *M103987*
 Batch: *M103869* *M104489*

FF 07-04-26
FF 07-04-24

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch to length as per Dwg D2012-105 & template D2012-105T1

FF 07-04-26
FF 07-04-24

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

FF 07-04-26
FF 07-04-24

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M102316
BR/a.m

8/5 07/05/25
07/05/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2012-105 PAR #: N/A Fault Category: Prod / FAB. PSS' mod & small NCR: Yes No DQA: 7/2 Date: 07/06/04
 QA: N/C Closed: 7/2 Date: 07.06.04

NCR: <u>31483</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07-04-09</u>	<u>2.0</u>	<u>4 struts scrap. Parts are under size by .120"</u>	<u>[Signature]</u> <u>05/10/02</u>	<u>Scrap, destroy & replace</u>	<u>07/04/09</u> <u>FF</u>	<u>8B</u> <u>07/04/09</u>	<u>[Signature]</u> <u>05/10/02</u>	<u>[Signature]</u> <u>07-04-09</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 31483

Part Number: D2012105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PS 7/05/31 (15)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PS 7/05/31 (15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D2012105

Job Completion



PS 7/05/31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

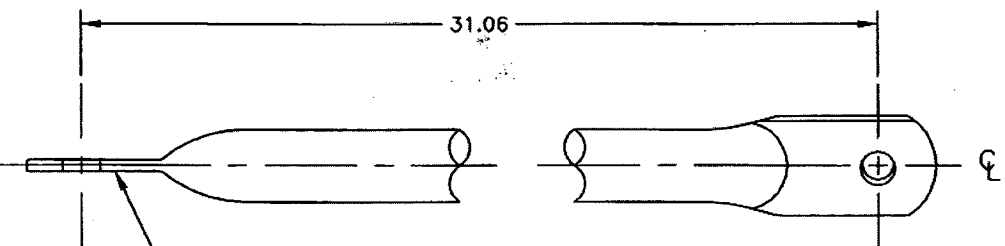
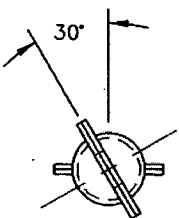
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
98/05/05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. 0
DATE		D2012-105	SHEET 1 OF 1
98.04.28		TITLE	SCALE
		ARM	NTS
A	92.06.04	NEW ISSUE - DRAWN FROM D2012	
B	96.06.25	30° ANGLE ROTATED 60° CCW	
C	97.09.03	CORRECTED VIEWS PER TSR A374	
D	98.04.28	ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
D1	98.05.25	ADD FINISH	

PUNCH BOTH ENDS PER SPEC
CONTROL DRAWING D2727

NOTES:

1. MAKE PER TEMPLATE DT8116 (WAS D2012-105)
2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.500 \times 0.035$ WALL
3. FINISH: POWDER COAT BLACK SANDTEX (4.3.5.F) PER DART QSI 005 4.3

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICEWORK ORDER
NO. 31483